

Date: Wednesday, 13/08/2008 12:40:06 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PLATE		
Job Number	: 41219			Part Number	: D33031		
Estimate Number	: 10424			Drawing Number	: D3303 REV. B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/08/2008 S.O. No. :			Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: 13/08/2008 Type : SMALL /MED FAB			Due Date	: 29/08/2008 Qty: 20 Um: Each		
Previous Run	: 40942						
Written By	:						
Checked & Approved By	: JUP 08.8.13						
Comment	: Est:A 04.09.07 New issue KJ/JLM Est Rev:B 06-06-28 Now On Waterjet JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S032	2024-T3 .032 sheet	
		Comment: Qty.: 0.3719 sf(s)/Unit Total : 7.4382 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.032" thick (M2024T3S.032)	Batch: <u>108575</u> <u>B 8-8-14</u>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3303 Dwg Rev: <u>B</u> <u>B 8-8-14</u> Prog Rev: <u>B</u>	<u>22</u>
		2-Deburr if necessary <u>B 8-8-14</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>B 8-8-14</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>8-8-14</u> <u>22</u>	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		<u>22</u>	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<u>22</u>
		<u>22</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 12:40:06 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 41219

Part Number: D33031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL

08 - 08 - 15

(X22)

Comment: INSPECT CHEMICAL CONVERSION COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 83

8/8/15

SP

(22X)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/19ff

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41219
Description: Plate	Part Number:	D3303-1
Inspection Dwg: D3303	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

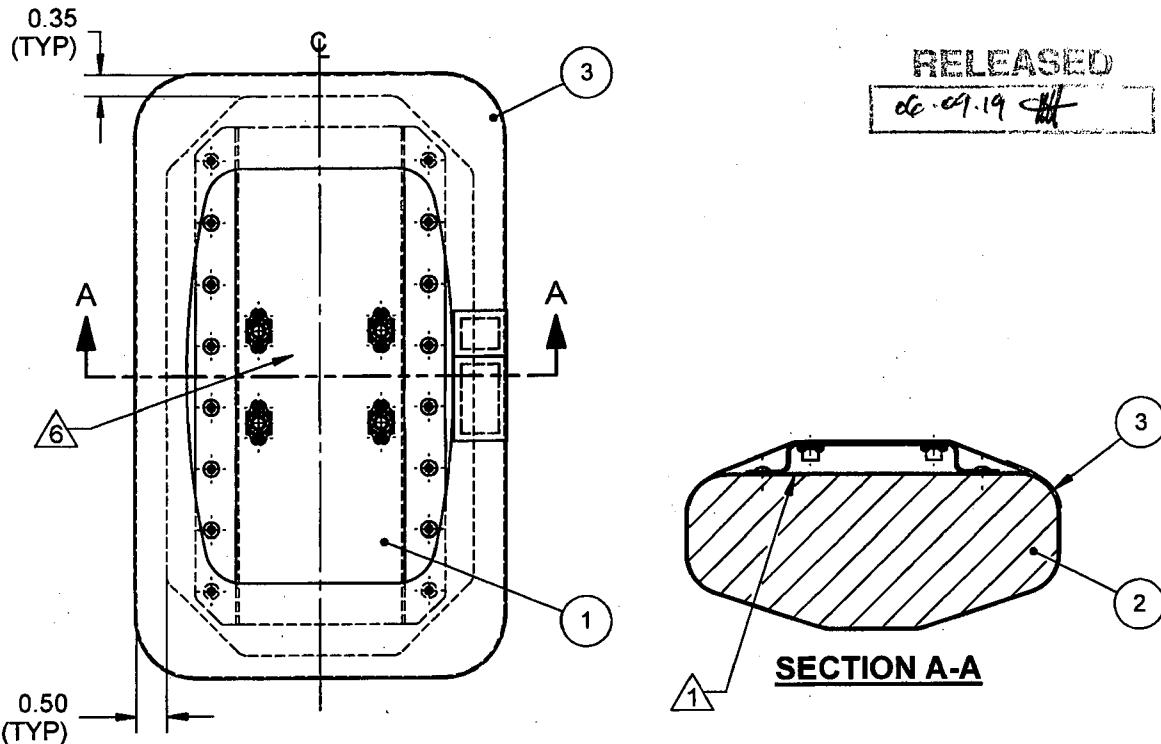
X First Article Prototype

Measured by:	<u>JB</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	<u>8-8-14</u>	Date:	<u>08/08/14</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	
B	07.01.16	5.00 was 5.000; Ø0.129 added	KJ/JLM	

DART

DESIGN <i>PF</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3303	REV. B	SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE	1:3
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE		
REV B	DATE 06.08.17	DESCRIPTION UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE		

**D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE COPY
(0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
RETURN TO
ENGINEERING
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT
ELIGIBILITY SEE PDA04-11"

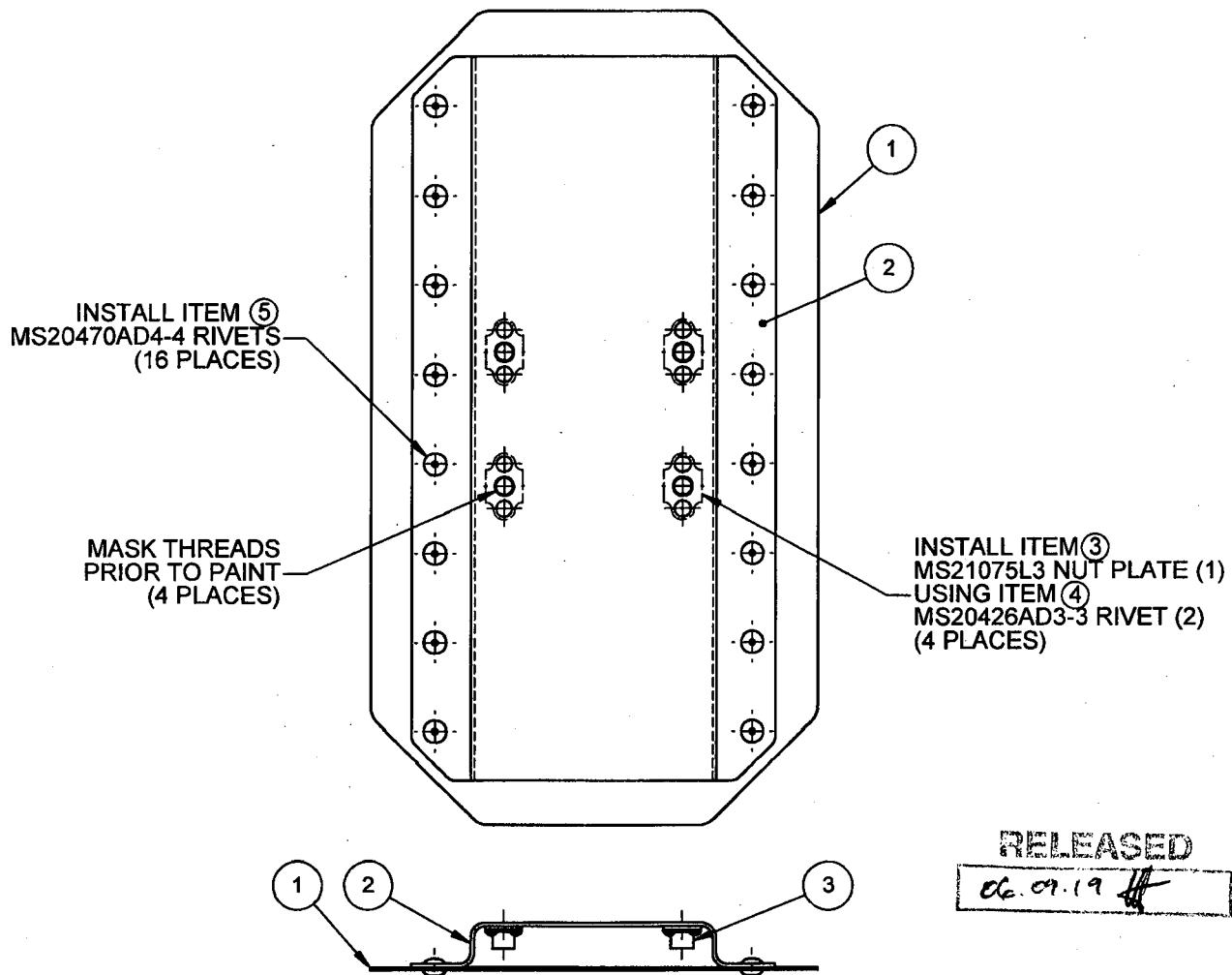
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO *10/19*

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DART

DESIGN <i>RF</i>	DRAWN BY <i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3303	
DATE 06.08.17	TITLE HEAD REST	REV. B	SHEET 2 OF 4

SCALE
1:2**D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

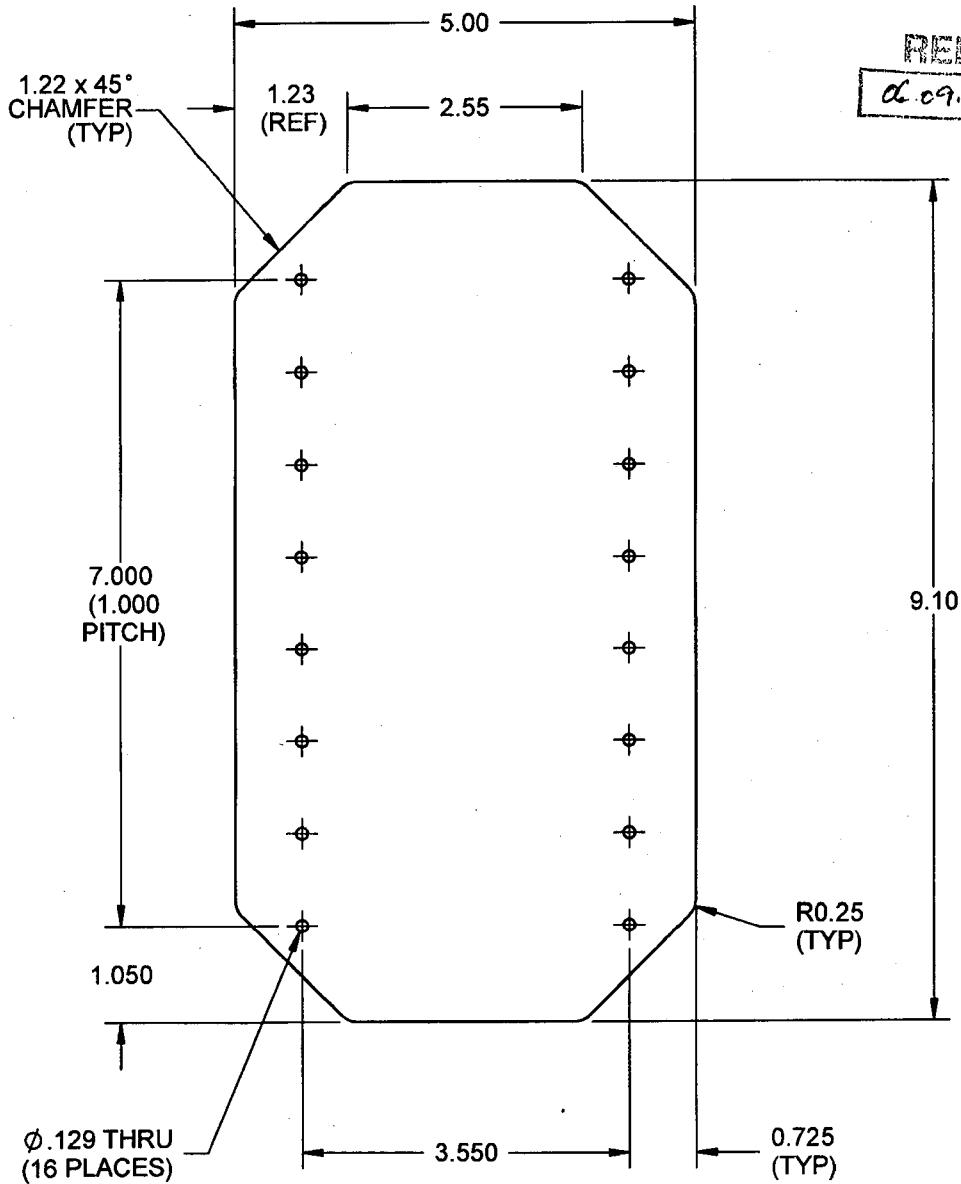
SHOP COPY
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DART

DESIGN <i>PF</i>	DRAWN BY <i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D3303
DATE 06.08.17	TITLE HEAD REST	REV. B SHEET 3 OF 4 SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

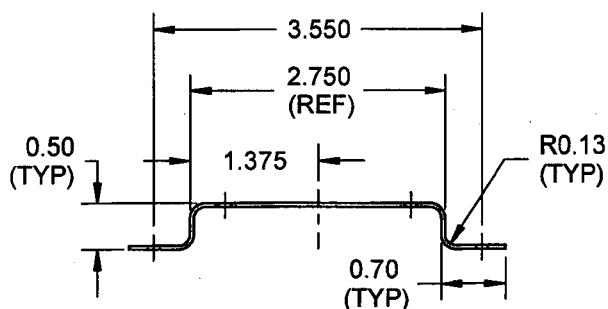
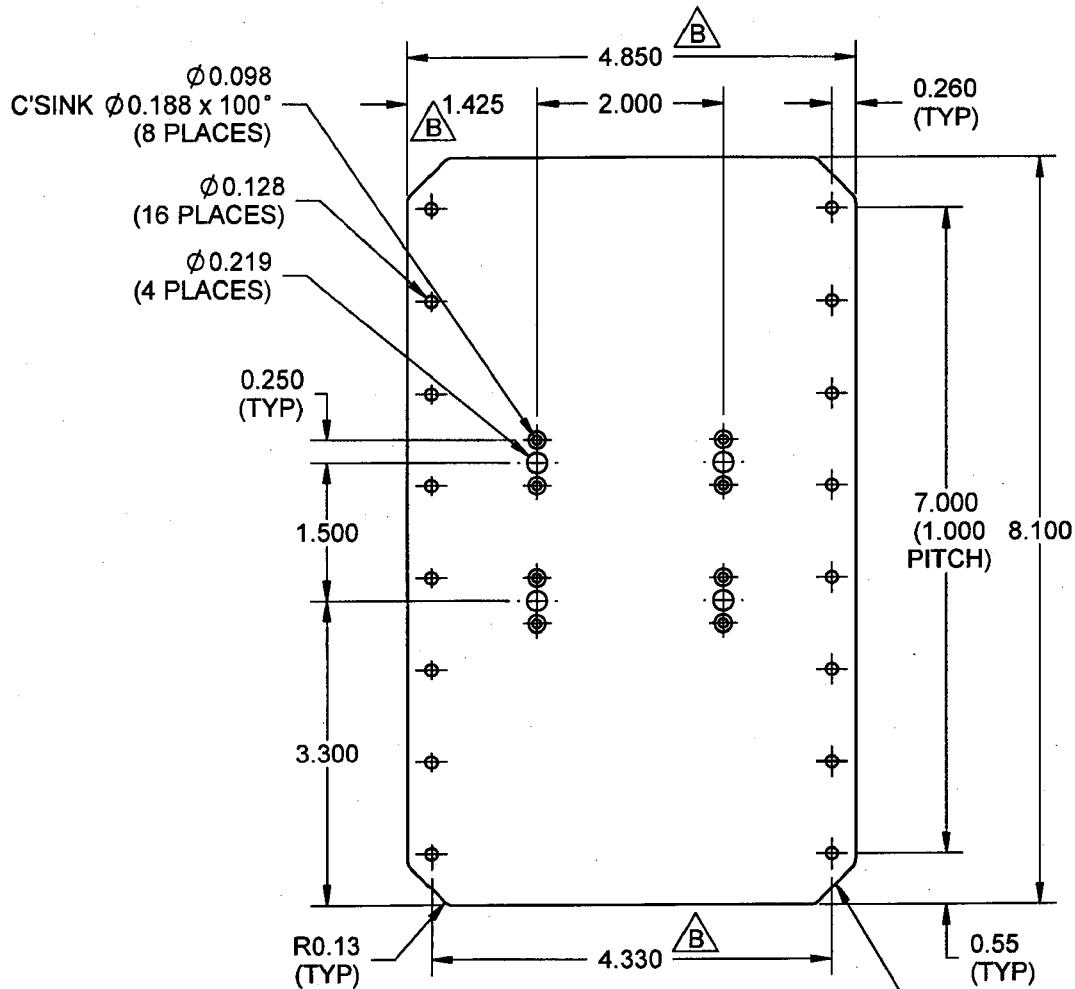
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DART

DESIGN <i>RF</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2	

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER
DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE
NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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